

Date: Wednesday, 1/23/2008 12:06:22 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	WELDMENT TOP PANEL		
Job Number	36942			Part Number	D36503		
Estimate Number	13029			Drawing Number	D3650 REV.B U/R		
P.O. Number				Project Number	N/A		
This Issue	1/23/2008	S.O. No.		Drawing Revision	B U/R		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	SMALL /MED FAB	Due Date	2/29/2008		
Previous Run	35708			Qty:	2	Um:	Each
Written By	<u>[Signature]</u>						
Checked & Approved By							
Comment	Est Rev:A New Issue 07-09-27 DD verified by: EC Est Rev:B ECN 1113P 08-01-22 DD						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S26GA	304/316 0.018 SHEET
		Comment: Qty.: 1.2023 sf(s)/Unit Total : 2.4045 sf(s) 304/316 SS sheet 26 ga (0.018" thick) Batch: <u>106996</u> <u>B 8-2-4</u>
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3650 Dwg Rev: <u>B</u> <u>B 8-2-4</u> Prog Rev: <u>B</u> 2-Deburr if necessary <u>B 8-2-4</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <u>B 8-2-4</u>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK <u>B 8-2-4</u>
		Comment: SECOND CHECK <u>B 8-2-4</u>
5.0	BRAKE NC	NC BRAKE <u>B 8-2-4</u>
		Comment: NC BRAKE Form as per Dwg D3650 <u>B 8-03-12</u> <u>B</u> <u>B</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3650-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 0803119
 QA: N/C Closed: _____ Date: _____

NCR: <u>36942</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
5	080312	One scrap piece positioned in wrong place Fabrication error	<u>VB</u> <u>080312</u>	Scrap piece Qty (+1)	<u>VB</u> 080312	<u>VB</u> 080312	<u>VB</u> 080312	<u>VB</u> 080312

NOTE: Date & initial all entries

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Drawing Name: WELDMENT TOP PANEL

Job Number: 36942

Part Number: D36503

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DARASSI Pwt.JRE

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



(1) Trim to fit

Comment: Weld assembly as per dwg D3650

PD 08-03-13 (1)

8.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10/08/13 (1)

9.0 QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING APPROVAL 08-03-13

10/08/14 (2)

Comment: INSPECT WORK TO CURRENT STEP

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: _____

PP038103

10/08/13 (3)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08-03-18 (4)

Job Completion



10/08-03-14

POSITIVE RECALL

EFFECTIVE 08-03-14 AUTH 4

RELEASED 08-03-14 DATE 08-03-14

6.1 Pick

3650-11

Batch: 37911

PD 08-03-13

10/08/13

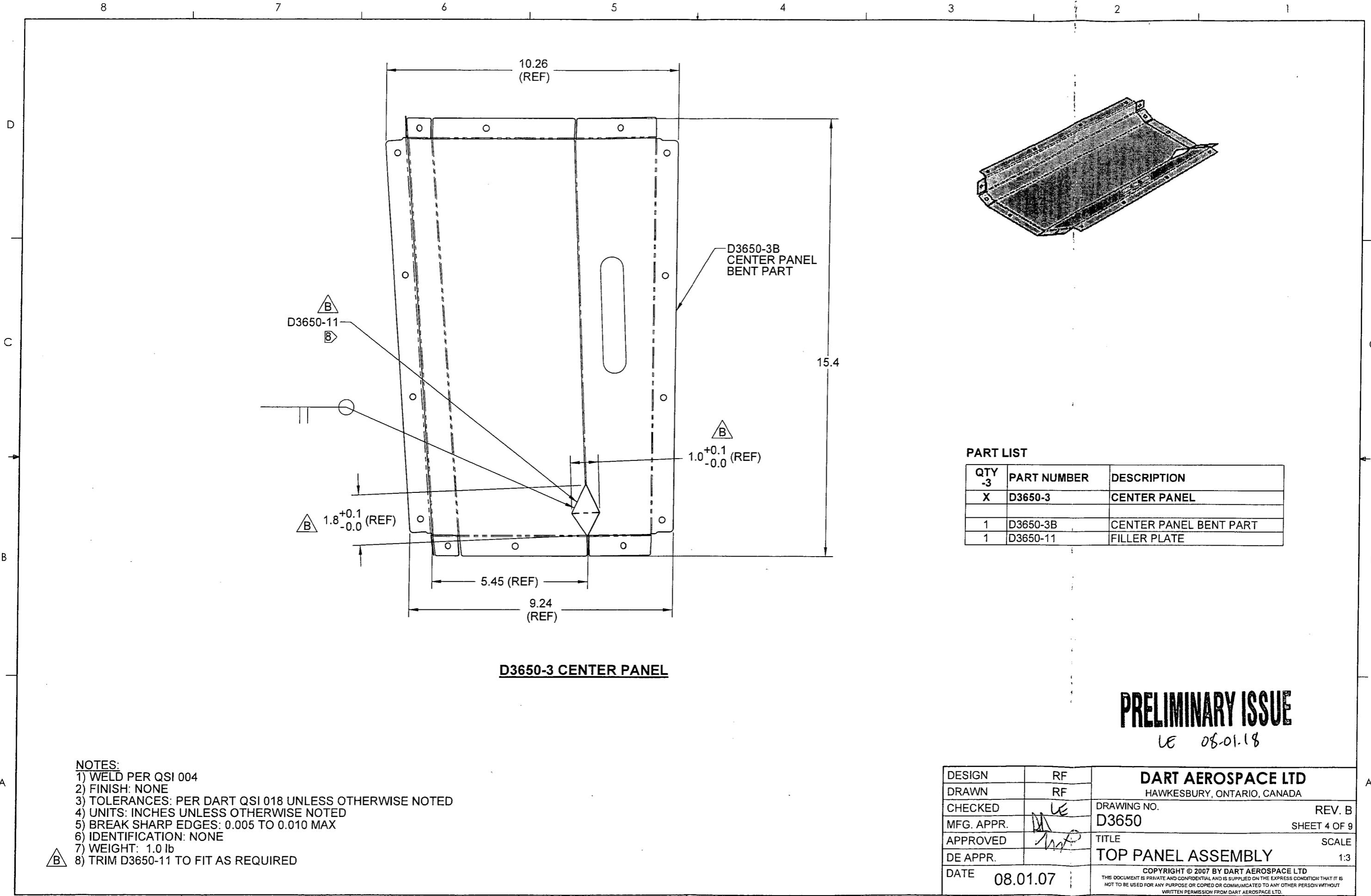
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

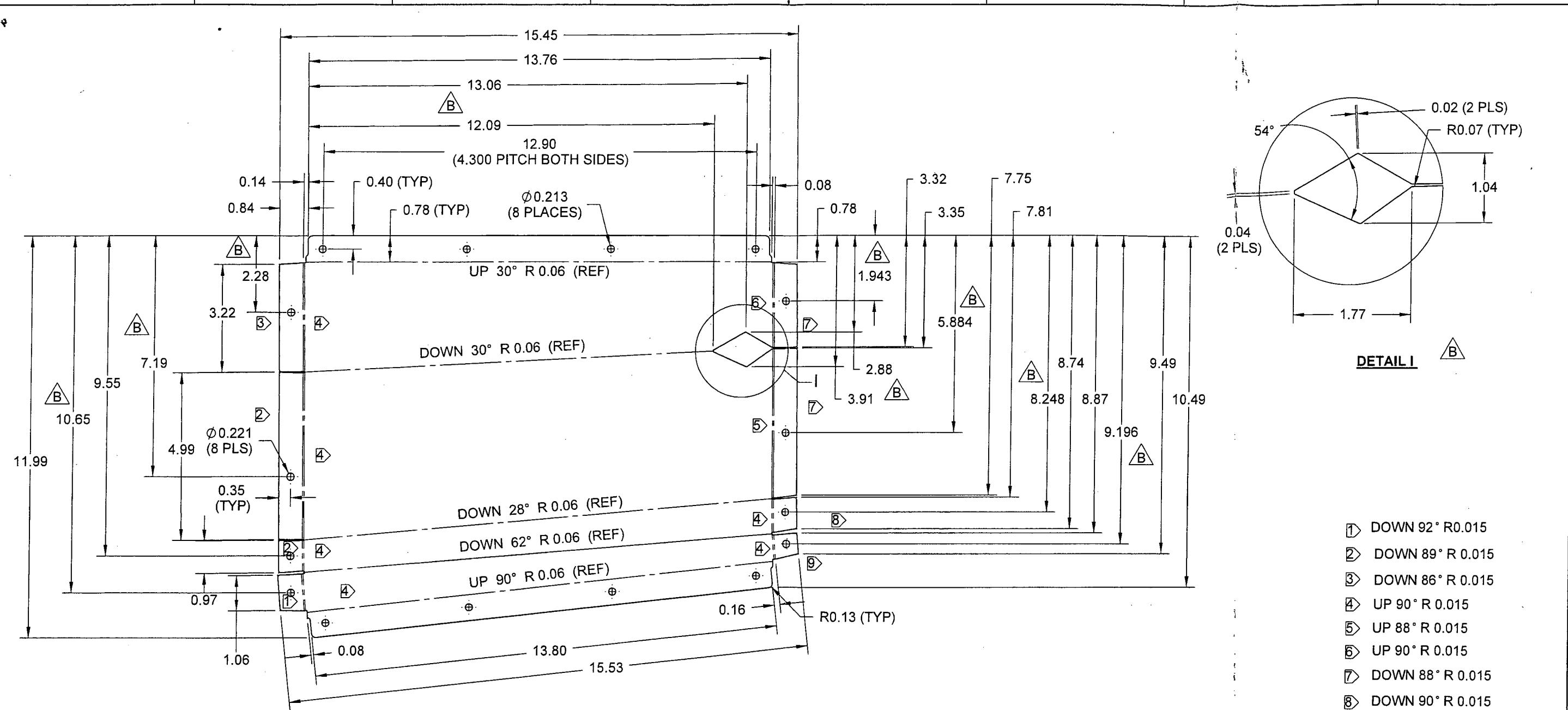
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1





- ① DOWN 92° R 0.015
- ② DOWN 89° R 0.015
- ③ DOWN 86° R 0.015
- ④ UP 90° R 0.015
- ⑤ UP 88° R 0.015
- ⑥ UP 90° R 0.015
- ⑦ DOWN 88° R 0.015
- ⑧ DOWN 90° R 0.015
- ⑨ DOWN 94° R 0.015

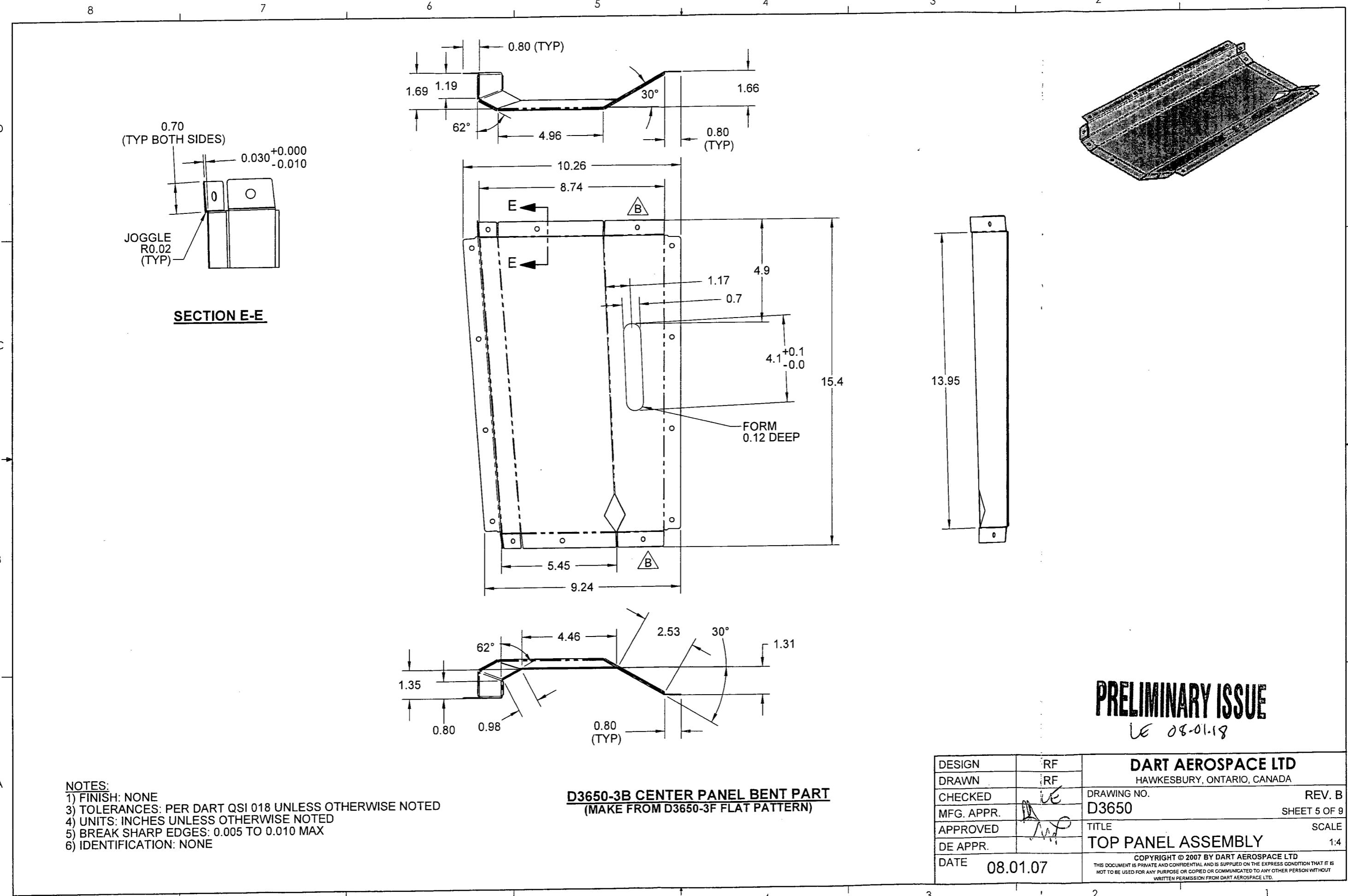
PRELIMINARY ISSUE

08.01.07

- D3650-3F NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	UE	DRAWING NO.
MFG. APPR.	W	REV. B
APPROVED	W	D3650
DE APPR.	W	SHEET 6 OF 9
DATE	08.01.07	TITLE
		TOP PANEL ASSEMBLY
		SCALE 1:3

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DART AEROSPACE LTD

Work Order: #3694D

Description: WEIMENT

Part Number: D3650-3

Inspection Dwg: D3650-3 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.221	+.005 -.001	.221	b			
.213	+.005 -.001	.213	x			
.40	+.030	.40	x			
15.45	+.030	15.45	x			
10.49	+.030	10.49	x			
15.53	+.030	15.53	b			
11.99	+.030	11.99	x			
12.40	+.030	12.40	x			
4.300	+.010	4.300	x			
12.09	+.030	12.09	x			
13.06	+.030	13.06	x			
1.943	+.010	1.943	x			
5.884	+.010	5.884	x			
8.248	+.010	8.248	x			
9.196	+.010	9.196	x			
13.86	+.030	13.80	x			
2.28	+.030	2.28	x			
7.19	+.030	7.19	x			
9.55	+.030	9.55	x			
10.65	+.030	10.65	x			
3.35	+.030	3.35	x			

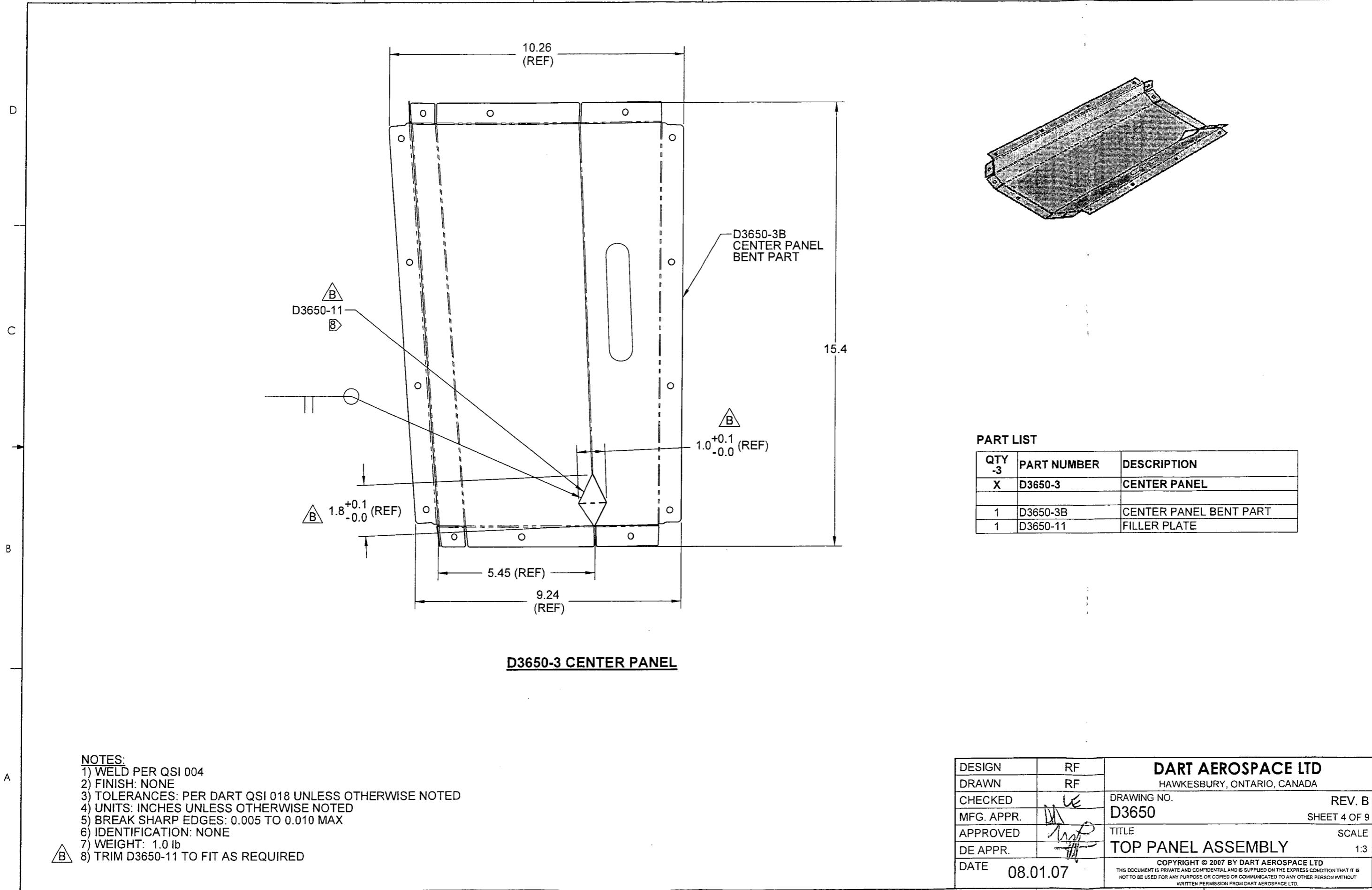
Measured by:	FB
Date:	8-3-4

Audited by:	J
Date:	08/17/04

Prototype Approval:	LE
Date:	08-03-13

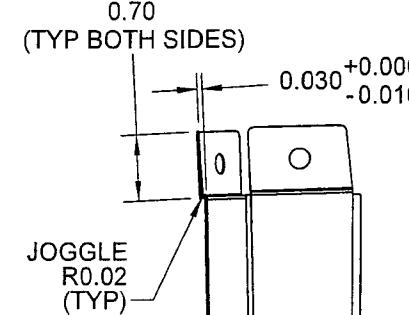
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1

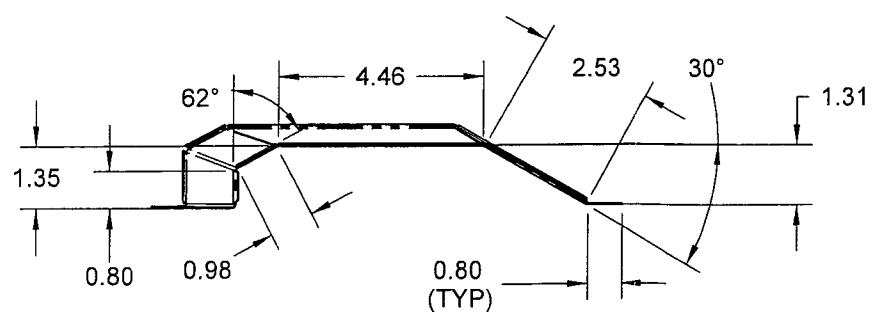
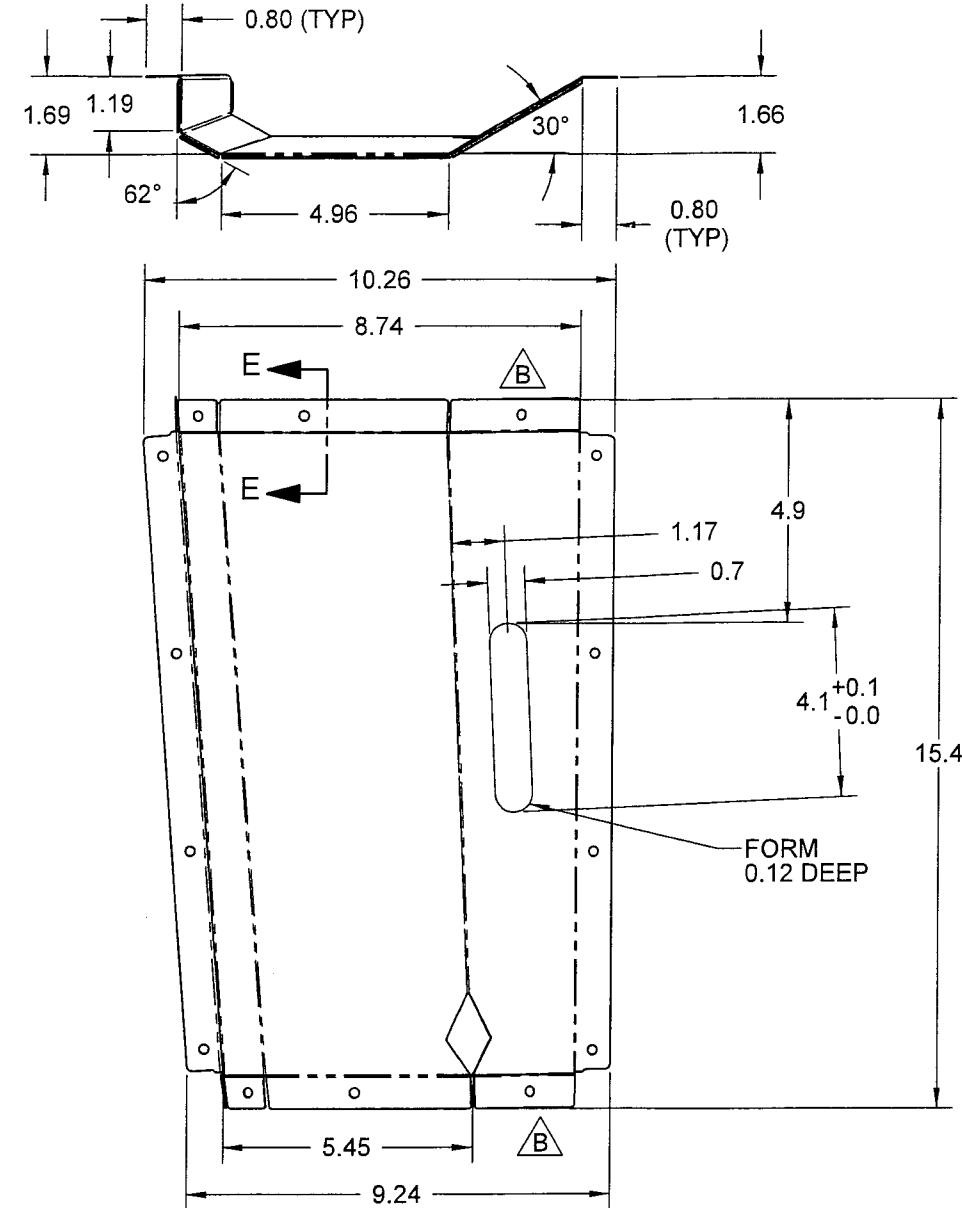


8 7 6 5 4 3 2 1

D



SECTION E-E



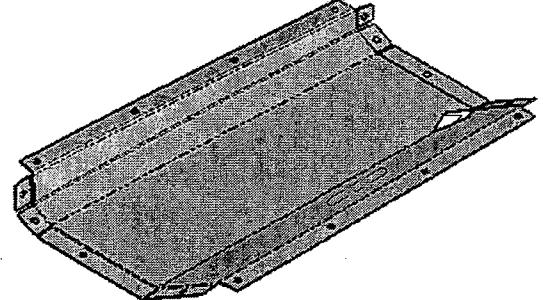
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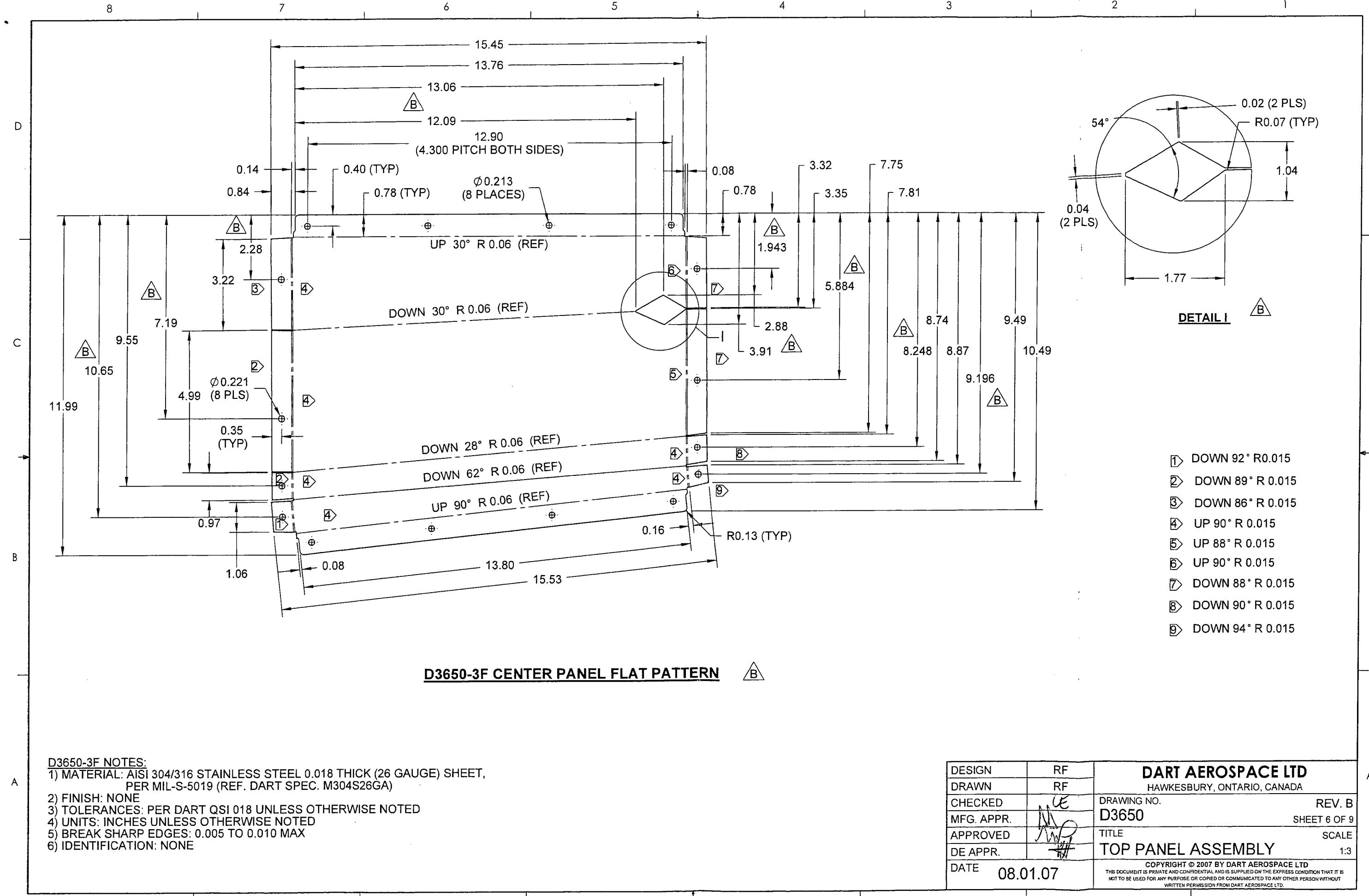
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- 6) IDENTIFICATION: NONE

D3650-3B CENTER PANEL BENT PART
(MAKE FROM D3650-3F FLAT PATTERN)

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UE	DRAWING NO.	
MFG. APPR.		D3650	REV. B
APPROVED			SHEET 5 OF 9
DE APPR.		TITLE	SCALE
DATE	08.01.07	TOP PANEL ASSEMBLY	1:4

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D3650-3F NOTES

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 - 2) FINISH: NONE
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DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>VE</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>MM</i>	D3650	SHEET 6 OF 9
APPROVED	<i>MM</i>	TITLE	SCALE
DE APPR.	<i>MM</i>	TOP PANEL ASSEMBLY	1:3
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